150 303

Work Order ID 67759

Wednesday, March 30, 2011 10:33:14 AM

Item ID: D2570 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bushing

Start Date: 3/30/2011 **Start Qty:** 160.00 **Cust Item ID:**

Required Date: 4/4/2011 **Req'd Qty:** 160.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-03-30 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2570	Rev B								
100	Hardinge CNC LATHE SMALL	0.00				161	Ø		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	Machine as per folio FA258□Deburr								
		11/4/25							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				161	6		
QC	**Memo**	0.00							
Quality Control		11/4/25							
120	QC8- Inspect parts - second check	0.00				161	5		
QC	**Memo**	0.00							
Quality Control		11-4-25							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67759

Wednesday, March 30, 2011 10:33:14 AM

Item ID: D2570 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bushing

Start Date: 3/30/2011 **Start Qty:** 160.00 **Cust Item ID:**

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Run Start **Stop**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: A	0.00				11/4/2011		1612	
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/4/2011

MF 11-04-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:33:19 AM

Work Order ID: 67759

Parent Item: D2570

Parent Item Name: Bushing

Start Date: 3/30/2011 **Required Date:** 4/4/2011

Start Qty: 160.00 **Required Qty:** 160.00

Comments: IPP E□02.08.29□Re-format; Removed finishing; Material change□KJ□
IPP F 07.07.06 rev B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	65.2100	0.0771	12.98526			
303 Round Bar 0.750													

Location	Loc Qty	Loc Code
MAT028	65.21	
117142	65.21	

11/4/25

13 ft

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77709
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.800	✓		SJ-9	
0.060	+/-0.005	.062	✓			
R0.010	+0.010/-0.000	R.015	✓			
Ø0.425	+0.000/-0.002	Ø.424	✓			
Ø0.257	+0.006/-0.001	Ø.255	✓			
Ø0.750	+/-0.010	Ø.747	✓			
0.030 x 20°	+/-0.010	.030 x 20°	✓			

Measured by:	SJ
Date:	11/4/25

Audited by:	pl
Date:	11.4.25

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

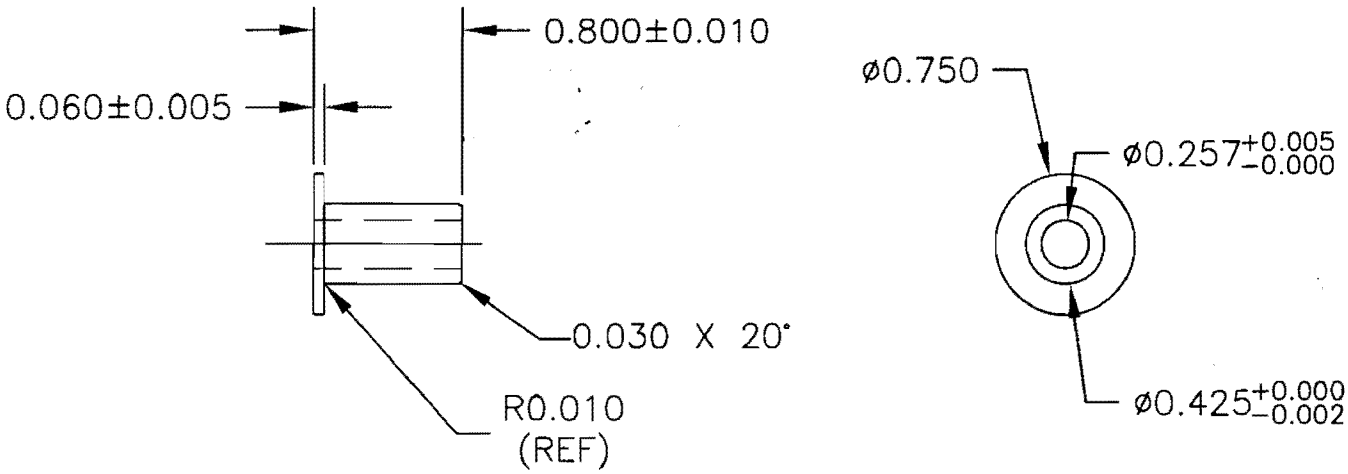
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2570	SHEET 1 OF 1
DATE		TITLE	SCALE
07.04.17		BUSHING	1:1

A	96.09.16	NEW ISSUE
B	07.04.17	UPDATE NOTES

RELEASED
07.06.28



D2570 BUSHING

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 67759
RH 11-03-30

D2570 BUSHING

1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
2) FINISH: NONE
3) ALL DIMENSIONS ARE INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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Dart Aerospace Ltd

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